

Date: Tuesday, 11/29/2005 6:53:41 PM  
User: Linda Lacelle

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: INNER AFT SADDLE
Job Number	: 25045		
Estimate Number	: 11082	Part Number	: D5957
P.O. Number	: N/A	Drawing Number	: D5957 REV A
This Issue	: 11/29/2005 S.O. No. : N/A	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: A
First Issue	: N/A	Material	: N/A
Previous Run	: N/A	Due Date	: 11/29/2005
Written By	: _____	Qty:	4 Um: Each
Checked & Approved By	: _____		
Comment	: Created By Auto Work Order		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	7075-T7351 8.25X7.75X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
D6101-007(7075-T7351)  
Size 2.50" x 7.50" X 8.25" (Grain along 7.50")  
Batch: \_\_\_\_\_

B25353 x4 En 06/11/09

## Tools:

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5957, Ensure Batch Number is entered

J.F. 06/11/09

2-Machine Keyway PTO

3-Deburr & Tumble

## Tools:

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

## Tools:

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

## Tools:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
05.11.03	2	CHAMFER 0.033 x 45° WAS ADDED AND CALLED (V). SIMILAR TO D2571 SEE ATTACHED	PH 05.11.03				→ 06.11.03	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 06/11/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
			ME					

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER AFT SADDLE

Job Number: 25045

Part Number: D5957

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*FL a.m 06/11/13 x 4*

Tools:

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*a.m 06/11/15 (4)*

Tools:

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FL 06 11 15 (4)*

Tools:

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*06/11/16 (4)*

Tools:

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/11/16 (4)*

Tools:

Job Completion



*C Lacelle*

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
<b>Description:</b> Inner Aft Saddle	<b>Part Number:</b>	<b>D5957</b>
<b>Inspection Dwg:</b> D5957 Rev. A		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D5957 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	<del>DT8682</del>	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.251	5.251	5.251	5.250		
D	6.995	7.005		7.001	7.002	7.000	7.000		
E	5.745	5.755		5.750	5.751	5.751	5.752		
F	4.745	4.755		4.752	4.752	4.752	4.752		
G	0.313	0.318	<del>DT8686</del>	0.314	0.314	0.314	0.314		
H	1.522	1.532		1.529	1.528	1.528	1.527		
I	3.048	3.058		3.054	3.054	3.054	3.053		
J	4.575	4.585		4.582	4.582	4.582	4.581		
K	0.313	0.318	<del>DT8686</del>	0.314	0.314	0.314	0.314		
L	0.240	0.260		0.255	0.258	0.258	0.260		
M	0.490	0.510		0.502	0.500	0.501	0.504		
N	0.240	0.260		0.255	0.258	0.257	0.259		
O	7.990	8.010		8.003	8.002	8.002	8.002		
P	0.240	0.260		0.259	0.258	0.259	0.259		
Q	0.307	0.312		0.311	0.311	0.311	0.311		
R	0.760	0.765		0.761	0.761	0.761	0.761		
S	0.490	0.510		0.498	0.499	0.498	0.499		
T	1.625	1.645		1.627	1.626	1.626	1.625		
U	2.000	2.020	<del>DT8696 A/B</del>	2.000	2.000	2.000	2.000		
V	0.023	0.043		0.033	0.033	0.033	0.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <b>S.G</b>
Date: <b>06/11/10</b>

Audited by: <b>SD</b>
Date: <b>06.11.10</b>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	



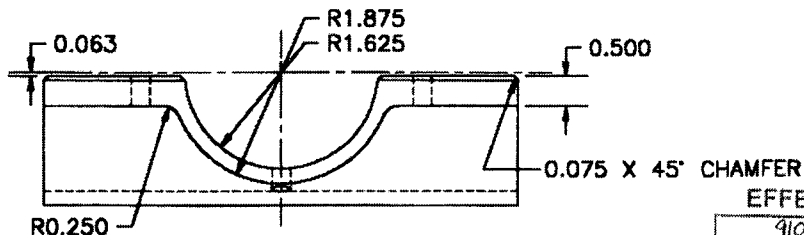
TOP 00.0505



DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED BW	DRAWING NO. D5957	REV. A SHEET 1 OF 1
DATE 97.05.06	TITLE INNER AFT SADDLE	SCALE	

MATERIAL: ~~7075-T651~~ OR 7075-T7351 QQ-A-250/12  
FINISH: ACID ETCH, ALODINE PER QSI 005 4.1  
PRIME, PAINT HI GLOSS WHITE (EXCEPT BORES) PER QSI 005 4.2  
BREAK ALL SHARP EDGES 0.010 TO 0.020

RELEASED  
97/05/14 DS

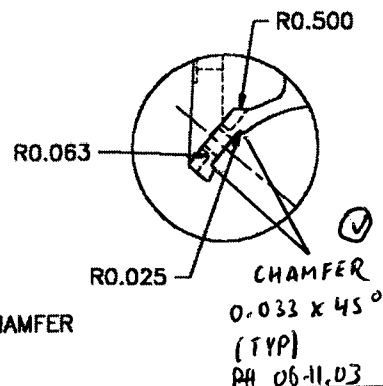
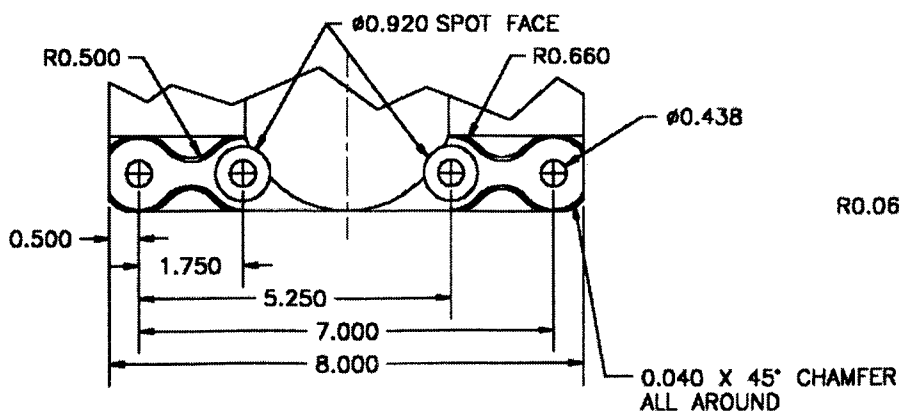
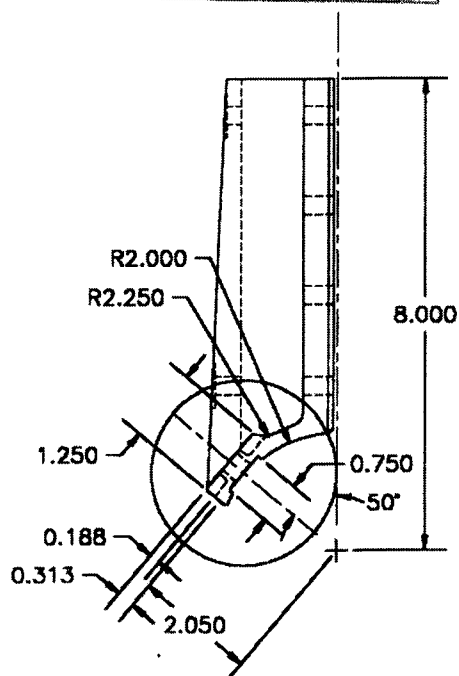
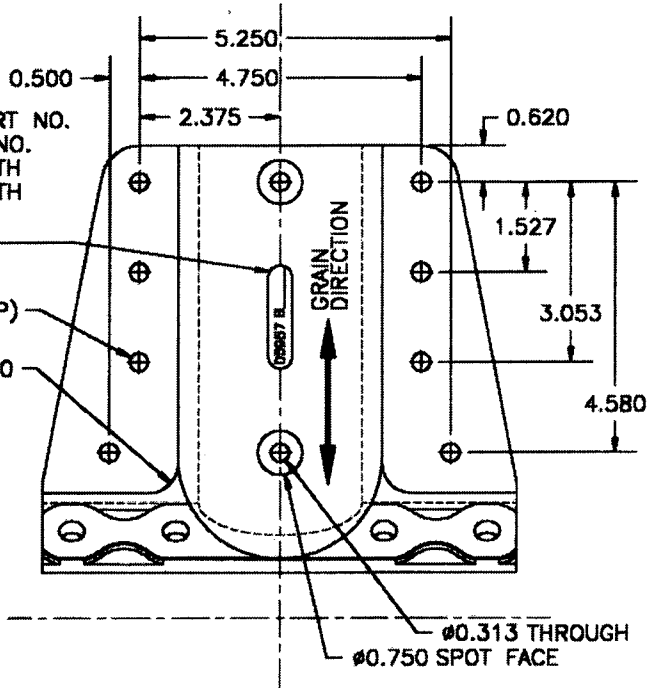


EFFECTIVE	DEOs
9102 98/05/04 OS	9079 98/06/22 DS

ENGRAVE PART NO.  
AND BATCH NO.  
TO MAX DEPTH  
OF 0.010 WITH  
MIN RAD OF  
0.010

Ø0.313(TYP)

R0.500



**Peter Hum**

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**From:** David Shepherd [dshepherd@dartaero.com]  
**Sent:** November 3, 2006 10:22 AM  
**To:** 'Peter Hum'  
**Subject:** RE: D5951/D5953/D5955/D5957

This change is acceptable to me.

David

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**From:** Peter Hum [mailto:phum@dartaero.com]  
**Sent:** Thursday, November 02, 2006 2:33 PM  
**To:** 'David Shepherd'  
**Subject:** D5951/D5953/D5955/D5957

David,

Last year we made a change to the ridges on the 205 saddles (we made a 0.033" X 45 degree chamfer) which I've attached.

Production is making a run of the extended high gear saddles D5951/D5953/D5955/D5957. Can the changes made to the 205 saddles be applied to the x-tended high gear saddles?

The extended high gear goes onto the same D205-634 skidtubes

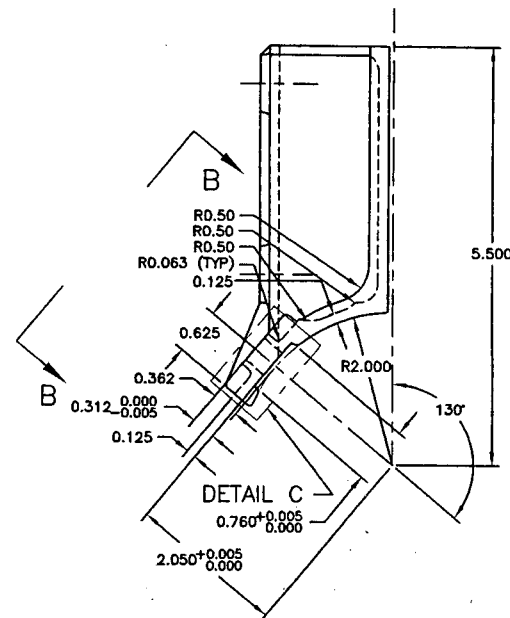
Chris Bell is currently updating the D5951/D5953/D5955/D5957 saddles and if this change is acceptable, we will add it in

Peter

--  
No virus found in this incoming message.  
Checked by AVG Free Edition.  
Version: 7.1.409 / Virus Database: 268.13.23/513 - Release Date: 11/2/2006

--  
No virus found in this outgoing message.  
Checked by AVG Free Edition.  
Version: 7.1.409 / Virus Database: 268.13.23/513 - Release Date: 11/2/2006

03/11/2006



# NOTES

MATERIAL: 7075-T7351 (Q0-A-250/12)  
 (REF DART SPEC. D6102-003)  
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
 DART QSI 005 4.3  
 BREAK ALL SHARP EDGES 0.010 TO 0.020  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



ENGRAVE PART AND BATCH NUMBER IN THIS  
 AREA TO MAX DEPTH OF 0.010



CHAMFER 0.063" x 45° AROUND THIS SURFACE  
 (TYPICAL 2 PLACES)



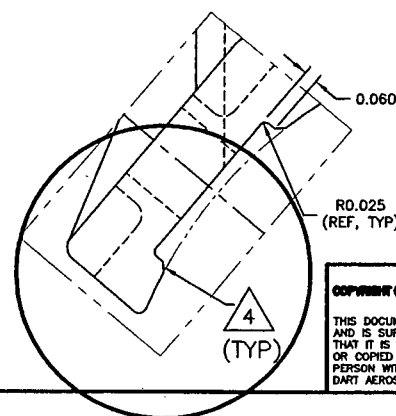
CHAMFER 0.063 x 45° ALL AROUND



CHAMFER 0.033 x 45° (SEE DETAIL C)



REFERENCE ONLY



REFERENCE ONLY

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED		APPROVED
DATE	05.07.13	TITLE
		INNER AFT SADDLE
		SCALE
		2:3

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**DART** DART AEROSPACE LTD.  
 MARKHAM, ONTARIO, CANADA

REV. E

SHEET 1 OF 1